

Date: Monday, 9/10/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

SPLIT-3

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34476 - 2
Estimate Number : 12883
P.O. Number : N/A
This Issue : 9/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL / MED FAB
Previous Run : 32646
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07.05.24 EC

Drawing Name : ARM

Part Number : D3560043
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : BL
Material : N/A
Due Date : 9/17/2007

Qty: 1/2 Um: Eac

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar 50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total: 16.3170 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M105646

mk 07/09/20 (1)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

mk 07/09/20 (1)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

2507/09/22

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2507/09/20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F 07/09/23



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE 3 34260834478 (2)

07.10.29 (2)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07.10.29 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.10.29 (2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.10.29 (2)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07.11.01 (2)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07.10.29

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.11.01 (2)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

07.11.01 (2)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



②

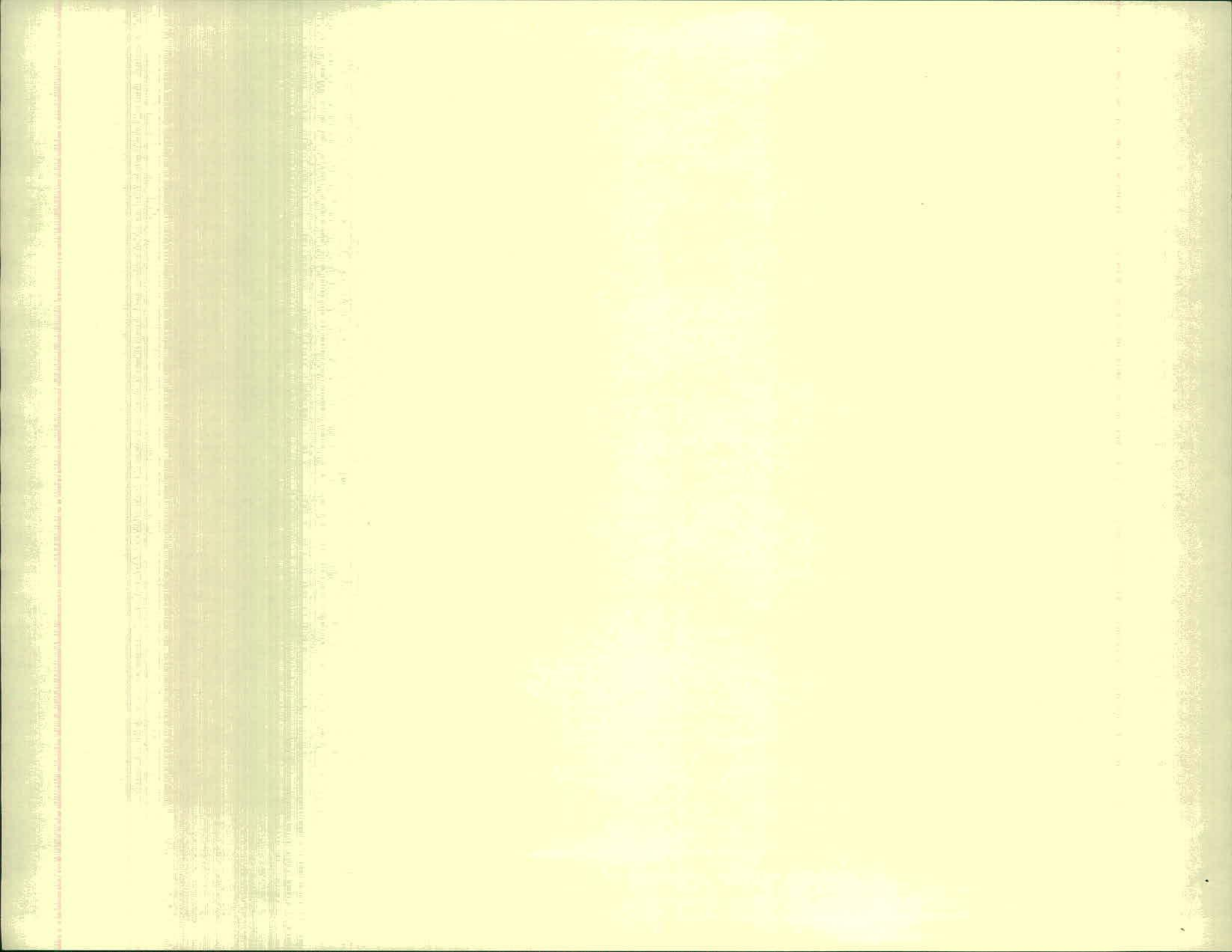
Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature/initials

Job Completion



6 07.11.02



DART AEROSPACE LTD		Work Order:	34476
Description: Arm		Part Number:	D3560-3
Inspection Dwg: D3560 Rev: B		Page 1 of 1	

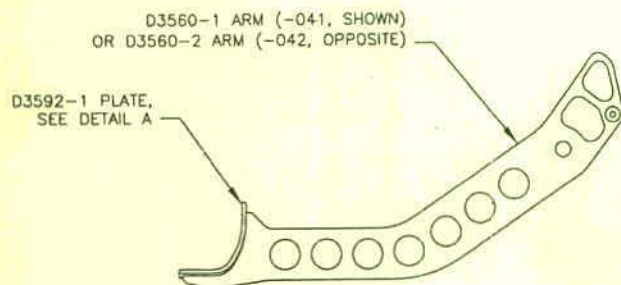
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

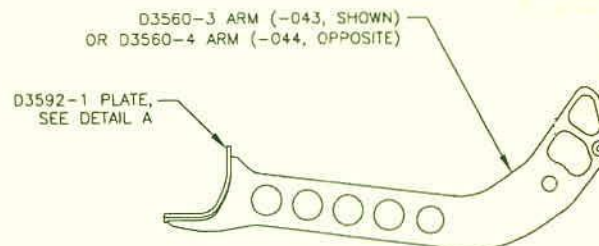
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.004	✓			
Ø0.900	+0.010/-0.001	.999	✓			
0.500	+/-0.010	.495	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.274	✓			
0.188	+/-0.010	.193	✓			
2.000	+/-0.010	.2001	✓			
1.750	+/-0.010	1.750	✓			
1.702	+/-0.010	1.705	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380 x 100°	✓			
0.250 Deep	+/-0.010	.253	✓			

Measured by: J.L. [Signature]	Audited by: BG	Prototype Approval:	N/A
Date: 07/09/21	Date: 07-09-21	Date:	N/A

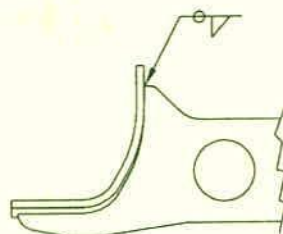
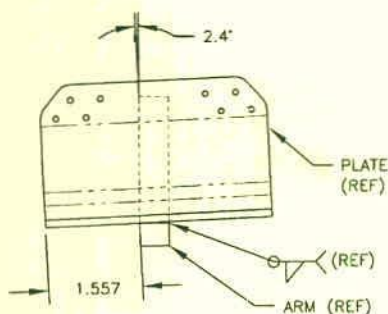
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM [Signature]	[Signature]



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

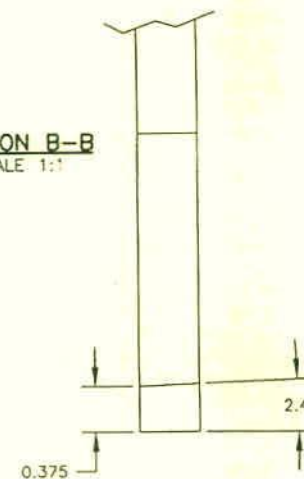
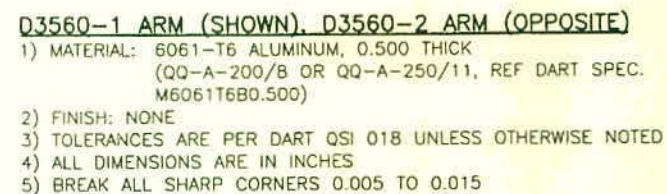
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07.06.19

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARVESEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE		TITLE ARM WELDMENT
07.06.19		SCALE 1:4

NO. 34476
WORK ORDER
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07-06-29

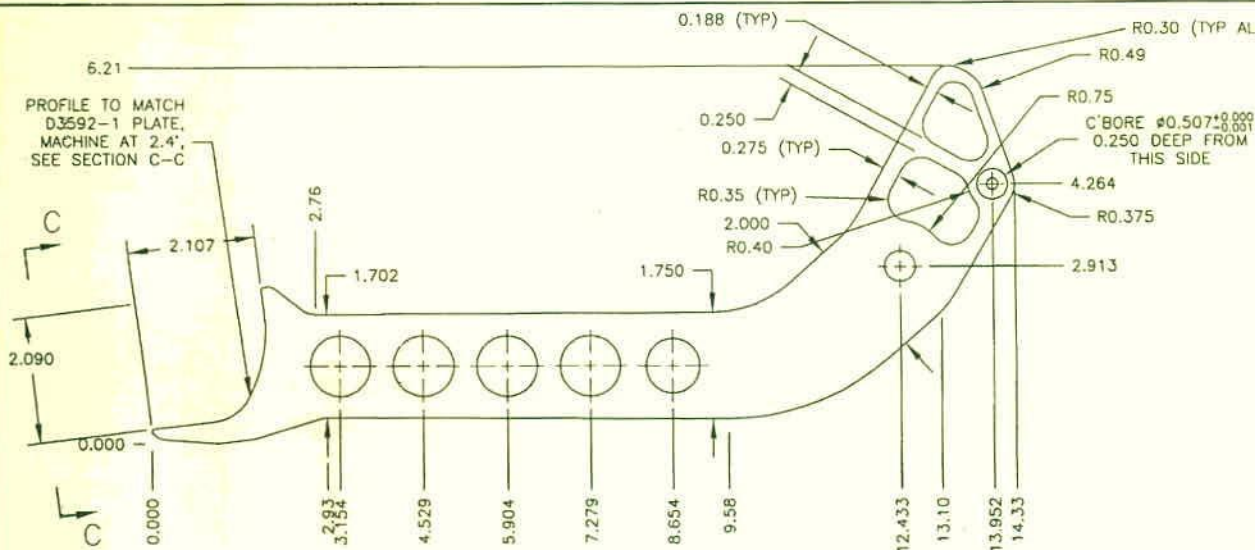
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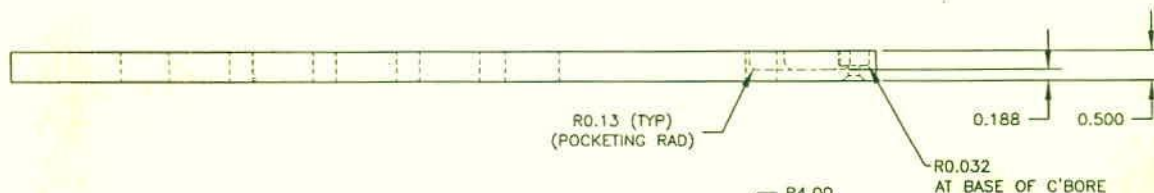
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WILLOWBURRY, ONTARIO, CANADA
GP	GP		
CHECKED	APPROVED	DRAWING NO.	REV. C
dt	dt	D3560	SHEET 2 OF 3
DATE	TITLE		SCALE
07.06.19	ARM WELDMENT		1:2

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4",
SEE SECTION C-C

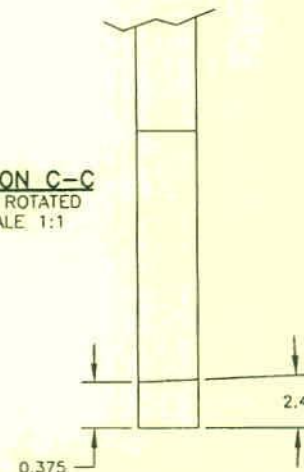


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
VIEW ROTATED
SCALE 1:1



RELEASED
07.06.19

$\phi 1.000$ THRU
(TYP 4 PLACES)

$\phi 0.900$ THRU
(1 PLACE)

$\phi 0.196$ (DRILL #9 REF)
C'SINK $\phi 0.385 \times 100$

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DESIGN	gp	DRAWN BY	gp	DART	DART AEROSPACE LTD. WARRICKSURY, OXFORD, CANADA
CHECKED	gp	APPROVED	gp	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2

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